



Dart Aerospace Ltd.
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Canada

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D3204-041
Job Sheet 169218-A



Part No: D3204-041

Job Qty: 2 ea

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/5/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/14/17	0.00	0.00	Start Up Large Fab-1		13L
100	Large Fab	2 pcs		12/14/17	0.00	2.60	Large Fab 8		13L
110	QC	2 pcs		12/14/17	0.00	0.00	QC9		PD 18.02.14
120	QC	2 pcs		12/14/17	0.00	0.00	QC5		PD 18.02.14
130	HandFinish	2 pcs		12/14/17	0.00	0.19	HandFinish1		19-02-14
140	Powdercoat	2 pcs		12/14/17	0.00	0.15	Powdercoat3		18-02-20
150	QC	2 pcs		12/14/17	0.00	0.00	QC3		18-02-20
160	Small Fab	2 pcs		12/15/17	0.00	0.13	Small Fab-3		18-02-20
170	QC	2 pcs		12/15/17	0.00	0.00	QC5		18-02-20
180	Packaging	2 pcs		12/15/17	0.00	0.00	Packaging3-1		18-02-20
190	QC21-SA	2 Ea		12/15/17	0.00	0.00	QC21		DAS FEB 20 2018

Part Op 100 - 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts D3204-1,3,5,13 in jig
Descriptions: number DT10295 for tacking parts together.3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and
D3204-5; weld parts then after parts have cooled; remove spacing rods...4- Inside measurement should be @ 5.9". Then
proceed to installing D3204-11 plate, then D3204-9 pedal.5- Fill #30 hole when parts are cooled to room temperature
quickly at around 150 amps...

140 - ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: _____ FINISH TIME:

180 - LOCATION : GA

M 136370 START: 11:45 O.V.T. 300° FINISH: 12:15.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	2 Ea (1 ea)	90-Start up Operation	
D3204-11	Plate	2 Ea (1 ea)	90-Start up Operation	
D3204-13	Gusset	4 Ea (2 ea)	90-Start up Operation	
D3204-3	Arm	2 Ea (1 ea)	90-Start up Operation	
D3204-5	Arm	2 Ea (1 ea)	90-Start up Operation	
D3204-9	Pedal	2 Ea (1 ea)	90-Start up Operation	
D3204-7	Bushing	4 Ea (2 ea)	160-Small Fab	

F156248 3x

F147440 1x

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3204-1	2	23	0
	D3204-11	2	8	0
	D3204-13	4	4	0
	D3204-3	2	8	0
	D3204-5	2	5	0
	D3204-9	2	2	0
160-Small Fab	D3204-7	4	23	0
Part Specifications				
Specifications could not be found.				

Plex 2/8/18 2:40 PM dart.lacelle.linda



Container No: S042195



Part: D3204-041

Serial No/Batch: S042195

Revision: D3204

Inspector:

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